

Work Order ID 64897



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Wednesday, December 22, 2010 1:19:27 PM

Item ID:	DSK078	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	D2893-1 TURNING DETAIL					
Start Date:	12/22/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	12/30/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-12-22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A								

100		0.00							
	MORI SEIKI CNC LATHE LARGE								
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)		SA	11/2/13					

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			SA	11/2/13					

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control				11.2.7					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, December 22, 2010 1:19:27 PM



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Item ID:	DSK078	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	D2893-1 TURNING DETAIL					
Start Date:	12/22/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	12/30/2010	Req'd Qty:	10.00		Customer:	
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban <input type="checkbox"/> Location:	<i>CNC</i>							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11.2.7

11/02/07
MF
11-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 22, 2010 1:19:31 PM

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Work Order ID: 64897

Parent Item: DSK078

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 12/22/2010

Required Date: 12/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005

Manufactured

No

Each

5.0000

1

10



SD 11/2/13

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT

5

60944

5

65122

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64897
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	Vern Sta 9	2.708	2.709	2.709	2.708	2.709
B	4.946	4.966		4.960	4.961	4.963	4.963	4.963
C	3.064	3.084		3.075	3.074	3.075	3.075	3.075
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.944	2.945	2.944	2.944
G	2.166	2.186		2.176	2.177	2.177	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.802	3.901
I	0.914	0.934		.926	.926	.926	.926	.926
J	0.022	0.042	M.C	.032	.032	.032	.032	.032
K	0.109	0.129		.118	.118	.118	.118	.118
L								
M								
N								
O								
P								

Measured by: *DA* Date: 11/2/3

Audited by: *RP* Date: 11.2.7

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	64887
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	Use	2.708	2.709	2.709	2.709	2.709
B	4.946	4.966		4.963	4.962	4.962	4.962	4.963
C	3.064	3.084		3.075	3.074	3.074	3.075	3.074
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.177	2.176	2.176	2.176
H	3.890	3.910		3.901	3.902	3.902	3.902	3.902
I	0.914	0.934		.926	.926	.926	.926	.926
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129	Use	.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: *SA* Date: 11/2/13

Audited by: *ml* Date: 11.2.7

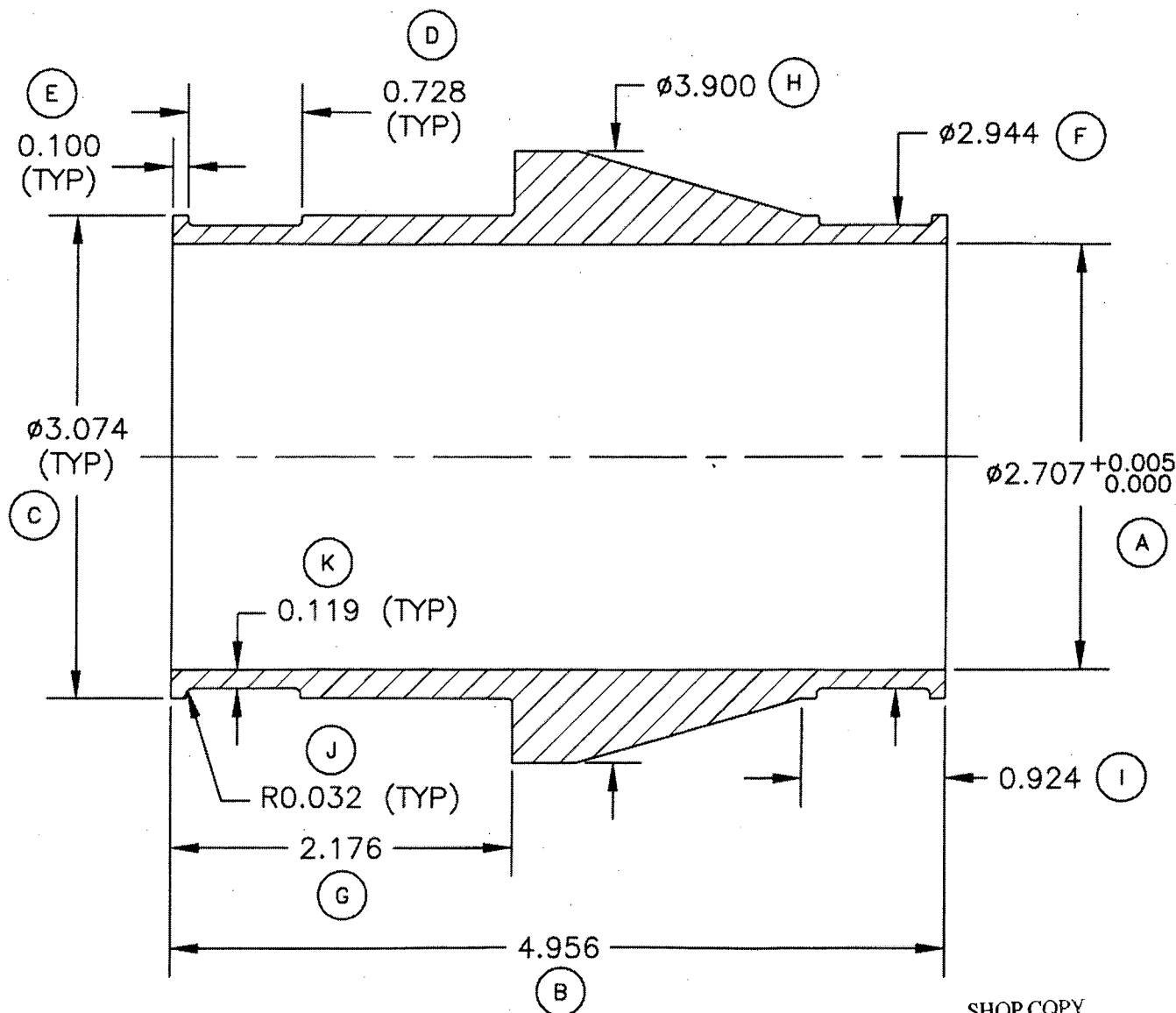
Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>SA</i>



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
#03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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NO. 04057

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